

W/JE1 7355



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBEM632V3021125-1
Job Sheet 180216



8-08

Part No: RBEM632V3021125-1

Job Qty: 6 ea

Part Name: Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/3/18

Job Tracking No:

Due Date: 8/13/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3021125 Rev. 2 IPP Rev. A 18.06.25 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		8/13/18	0.00	0.00	Start Up Waterjet2		DL 18/08/12
100	Waterjet	6 pcs		8/13/18	0.00	1.20	Waterjet 2 OMAX		DL 18/08/12
110	QC	6 pcs		8/13/18	0.00	0.00	QC2 Waterjet-4		DL 18/08/12
120	Mill Conv	6 pcs		8/13/18	0.50	1.50	Mill Conv 2		DL 18/08/12
130	QC	6 pcs		8/13/18	0.00	0.00	QC2 Machining-5		DL 18/09/19
140	QC	6 pcs		8/13/18	0.00	0.00	QC8 Machining-5		DL 18-09-19
180	Outsource	6 pcs		8/13/18	0.00	0.00	Outsource13		DL 18-09-19
190	Packaging	6 pcs		8/13/18	0.00	0.00	Packaging2		DL 18-09-19
200	QC	6 pcs		8/13/18	0.00	0.00	QC6		DL 18-09-19
210	Powdercoat	6 pcs		8/13/18	0.00	0.60	Powdercoat13		DL 18-09-19
220	QC	6 pcs		8/13/18	0.00	0.00	QC3		DL 18-09-19
230	Packaging	6 pcs		8/13/18	0.00	0.00	Packaging3-2		DL 18-09-19
240	QC21-SA	6 Ea		8/13/18	0.00	0.00	QC21		DL 18-09-19

Part Op 100 - 1-Cut as per DWG. DWG. Rev: 1 PROG. Rev: 1 2-Deburr if necessary
 Descriptions: 120 - 1-Machine as per DWG. 2-Deburr
 180 - -Issue P/O to GROUPE ALTECH: P/O 0041089 Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required
 190 - Receive
 210 - START TIME: 10:15 OVEN TEMPERATURE: 300 FINISH TIME: 10:45 No powder coat at this location as per note 3.
 220 - Ink stamp as per DWG.
 230 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-0.500X4.000	4140 Steel Bar 0.500 X 4.000	.8640 ft (.144 ea)	90-Start up Operation	S042421

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-0.500X4.000	1	1	0

Part Specifications

Specifications could not be found.



Container No: S101282



Part: RBEM632V3021125-1

Job No: 180216

Serial No/Batch: S101282

Revision: 2

Inspector:

Exp Date:

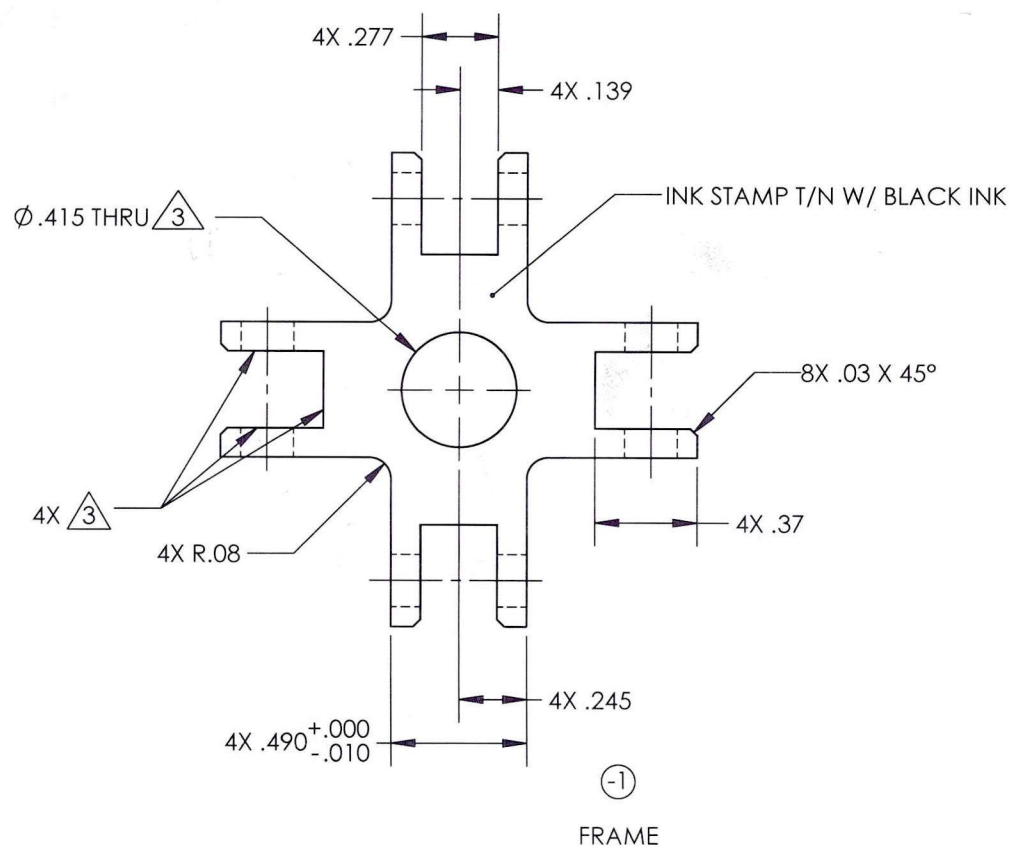
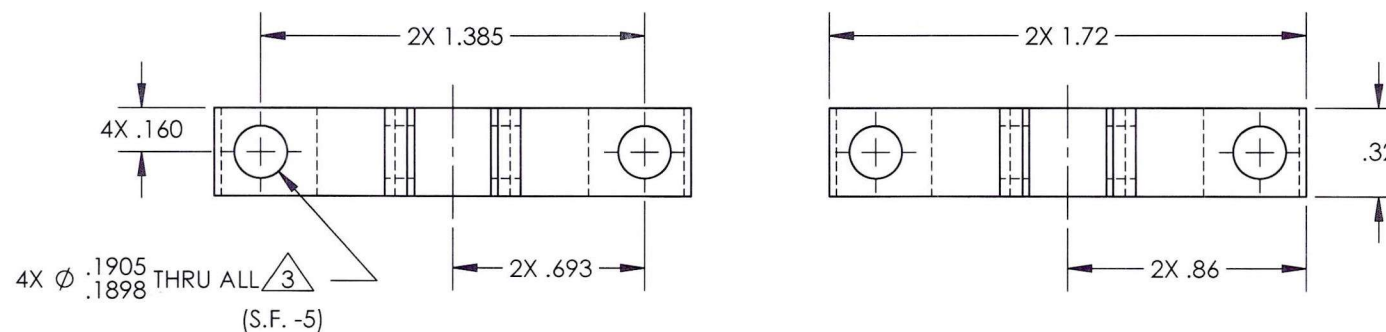
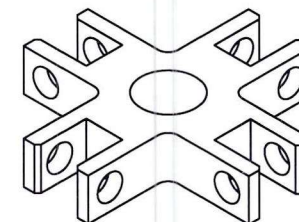
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/12/18

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



NOTES:

1. ZINC PLATE SPEC. ASTM B633 TYPE I SC2.
2. POWDER COAT YELLOW SPEC. FED # 13538.
3. NO POWDER COAT ON SURFACE.

DART AEROSPACE	
TITLE EXTRACTOR	
DWG NO.	REV
RBEM632V3021125-1	2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH SEE NOTES	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVAJK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 3:2	DATE 3/23/2016
SHEET 2 OF 6	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other		AGAINST DEPARTMENT/PROCESS			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	☐ OTHER : _____	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

PURCHASE ORDER PO041089

Tel (613) 632-5200

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041089
PO Date: 9/20/18
Due Date: 9/25/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180216	RBEM632V3021125-1	Frame -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color: Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/25/18	8 pcs	0 pcs	8 pcs	\$11.25/pcs	\$90.00

SEP 25 2018

Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/24/18 7:52 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

012909- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
25-Sep-2018		SVETLANA DORZHIYEVA		041089				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM632V3021125-1 Rev.	RBEM632V3021125-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	8	8	0	0	0

DAS
38
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.